

October-19-12 2:37:12 PM

Page 1

DAS
14
9-89

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

DQA: _____ Date: _____

QA Closed: _____ Date: _____

Work Order: _____ Part No. _____ NCR No. _____				DISPOSITION Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Work Order Update <input type="checkbox"/>		AGAINST DEPARTMENT/PROCESS <div style="display: flex; justify-content: space-between;"> <div> Skid-tube <input type="checkbox"/> Machining <input type="checkbox"/> Thermoforming <input type="checkbox"/> Large Fab <input type="checkbox"/> </div> <div> Crosstube <input type="checkbox"/> Small Fab <input type="checkbox"/> Finishing <input type="checkbox"/> Composite <input type="checkbox"/> </div> <div> Water Jet <input type="checkbox"/> Prod. Eng. Coord. <input type="checkbox"/> Rec/Store/Packaging <input type="checkbox"/> Supplier <input type="checkbox"/> </div> <div> Engineering <input type="checkbox"/> Quality <input type="checkbox"/> Other <input type="checkbox"/> </div> </div>					
Root Cause	Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector		
Doc/Data <input type="checkbox"/>											
Equip/Tooling <input type="checkbox"/>											
Operator <input type="checkbox"/>											
Material <input type="checkbox"/>											
Setup <input type="checkbox"/>											
Other <input type="checkbox"/>											
Process <input type="checkbox"/>											
Supplier <input type="checkbox"/>											
Training <input type="checkbox"/>											
Unapproved <input type="checkbox"/>											

FAULT CATEGORY				
Landing Gear <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric to O/S <input type="checkbox"/> Cracks <input type="checkbox"/> Crushed/Crimped. <input type="checkbox"/> Cuffs <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Ripples in Bend <input type="checkbox"/> Torque Waves in Extrusion <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube	General <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damaged <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drill Holes <input type="checkbox"/> Drawing <input type="checkbox"/> Finish <input type="checkbox"/> Folio	<input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Maintenance <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Offset <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence <input type="checkbox"/> Outside Dimensions	<input type="checkbox"/> Ovalized <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge	<input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled <input type="checkbox"/> Other

91936

October-19-12 2:37:12 PM

N900040100

Setup Start *NS1*

Stop *NS2*

Start Date: 10/18/12 **Start Qty:** 8.00 ***8***

Cust Item ID:

Required Date: 11/09/12 **Req'd Qty:** 8.00 ***Q***

Customer:

Reference:

Run Start *NR1*

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

Stop *NR2*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

130

0.00

130

0.00

HandFXtube

Hand Finishing Crosstubes

Memo

Per note 8 on page 1 of dwg D2892, Prep inner concave surface of support and apply 3M Scotch-Weld as per dwg.
24h of cure time

120867

140

QC3- Inspect Part Finish

0.00

140

0.00

QC

Quality Control

Memo

170

Identify as per dwg & Stock Location: LG 52

0.00

170

0.00

Packaging

Packaging

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

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QA Closed: _____ Date: _____

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Work Order ID 91936***91936***

Page 3

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Item ID: D2892-1

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Support

Start Date: 10/18/12 Start Qty: 8.00

8

Cust Item ID:

Required Date: 11/09/12 Req'd Qty: 8.00

8

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

180

QC21- Final Inspection - Work Order Release

0.00

180

QC

Memo

0.00

Quality Control

12/12/13

ME
12-12-12

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

DQA: _____ Date: _____

QA Closed: _____ Date: _____

Work Order: _____ Part No. _____ NCR No. _____				DISPOSITION Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Work Order Update <input type="checkbox"/>		AGAINST DEPARTMENT/PROCESS <div style="display: flex; justify-content: space-between;"> <div> Skid-tube <input type="checkbox"/> Machining <input type="checkbox"/> Thermoforming <input type="checkbox"/> Large Fab <input type="checkbox"/> </div> <div> Crosstube <input type="checkbox"/> Small Fab <input type="checkbox"/> Finishing <input type="checkbox"/> Composite <input type="checkbox"/> </div> <div> Water Jet <input type="checkbox"/> Prod. Eng. Coord. <input type="checkbox"/> Rec/Store/Packaging <input type="checkbox"/> Supplier <input type="checkbox"/> </div> <div> Engineering <input type="checkbox"/> Quality <input type="checkbox"/> Other <input type="checkbox"/> </div> </div>					
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FAULT CATEGORY				
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Picklist Print

October-19-12 2:37:12 PM

Page 1

Work Order ID: 91936

Parent Item: D2892-1

Start Date: 10/18/12

Required Date: 11/09/12

Parent Item Name: Support

Start Qty: 8.00

Required Qty: 8.00

Comments: IPP C02.11.26Added P/O KJ
IPP D 08.03.19 Re-format EC verified by: DD IPP Rev:E 11.08.04 as per dwg
rev.B DD verf:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
DSK077		Manufactured	No			110	Each	4.0000	0.5	4			
D2892-1 TURNING DETAIL													

Location

Loc Qty

Loc Code

MAT060

4

82700

4

4

FA 12/10/30

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

DQA: _____ Date: _____

QA Closed: _____ Date: _____

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Setup <input type="checkbox"/>											
Other <input type="checkbox"/>											
Process <input type="checkbox"/>											
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FAULT CATEGORY			
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DART AEROSPACE LTD		Work Order:	91936
Description: Ø2.500 Support		Part Number:	D2892-1
Inspection Dwg: D2892	Rev: B	Page 1 of 1	

FIRST ARTICLE INSPECTION DIMENSION SHEET

☒ First Article ☐ Prototype

				Record Actual Dimensions				
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	5
HAAS Section								
AA	0.115	0.135		0.133	0.133	0.133	0.133	0.133
AB	0.290	0.310		0.291	0.291	0.291	0.291	0.291
AC	0.040	0.060		0.052	0.052	0.054	0.055	0.056
AD	0.115	0.135		0.126	0.126	0.126	0.126	0.126
AE	0.240	0.260		0.248	0.248	0.248	0.248	0.248
AF	0.188	0.193		0.188	0.188	0.188	0.188	0.188
AG	0.240	0.260		0.250	0.250	0.250	0.250	0.250
AH	1.126	1.146		1.140	1.139	1.140	1.140	1.140
AI	0.454	0.474		0.461	0.461	0.461	0.461	0.461
AJ	0.240	0.260		0.250	0.250	0.250	0.250	0.250
AK	0.053	0.073		0.063	0.063	0.063	0.063	0.063
AL	0.257	0.262		0.257	0.257	0.257	0.257	0.257
AM	1.663	1.683		1.675	1.675	1.675	1.674	1.675
AN	0.053	0.073		0.063	0.063	0.063	0.063	0.063
AO	0.022	0.042		0.032	0.032	0.032	0.032	0.032
AP	2.779	2.789		2.784	2.784	2.784	2.784	2.784
AQ								
AR								
AS								
AT								
Accept/Reject								

Measured by:	D.A. 08 DAS 2-83	Date:	12/11/01
Audited by:	14 2-83	Date:	12/11/05
Prototype Approval:		Date:	

Rev	Date	Change	Revised by	Approved
A	02.12.12	New Issue	KJ/RF	
B	08.04.21	Reformat	KJ/JLM	
C	12.01.31	Dwg Rev updated	KJ	AA

DART AEROSPACE LTD		Work Order:	91936
Description: Ø2.500 Support		Part Number:	D2892-1
Inspection Dwg: D2892	Rev: B	Page 1 of 1	

FIRST ARTICLE INSPECTION DIMENSION SHEET

☒ First Article ☐ Prototype

				Record Actual Dimensions				
Dim	Min	Max	Go/No Go Gauge	16	17	18	4	8
HAAS Section								
AA	0.115	0.135		0.133	0.133	0.133		
AB	0.290	0.310		0.291	0.291	0.291		
AC	0.040	0.060		0.055	0.058	0.057		
AD	0.115	0.135		0.126	0.126	0.126		
AE	0.240	0.260		0.248	0.248	0.248		
AF	0.188	0.193		0.188	0.188	0.188		
AG	0.240	0.260		0.250	0.250	0.250		
AH	1.126	1.146		1.140	1.144	1.142		
AI	0.454	0.474		0.460	0.456	0.456		
AJ	0.240	0.260		0.250	0.250	0.250		
AK	0.053	0.073		0.063	0.063	0.063		
AL	0.257	0.262		0.257	0.257	0.257		
AM	1.663	1.683		1.674	1.675	1.674		
AN	0.053	0.073		0.063	0.063	0.063		
AO	0.022	0.042		0.032	0.032	0.032		
AP	2.779	2.789		2.784	2.784	2.784		
AQ								
AR								
AS								
AT								
Accept/Reject								

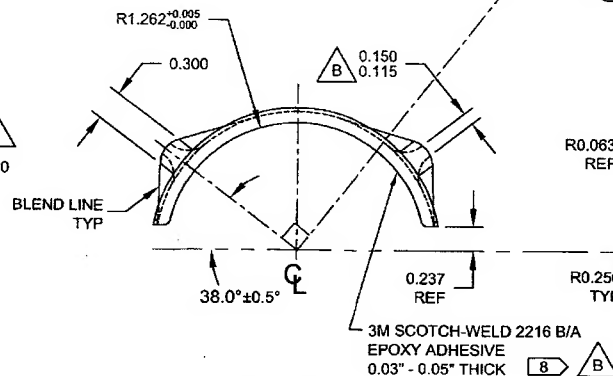
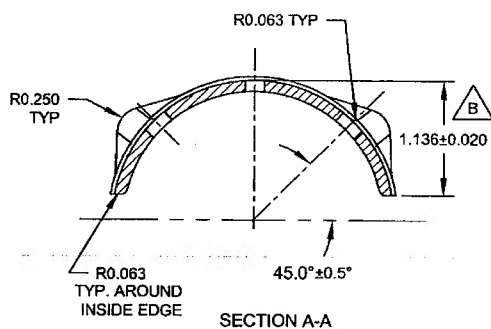
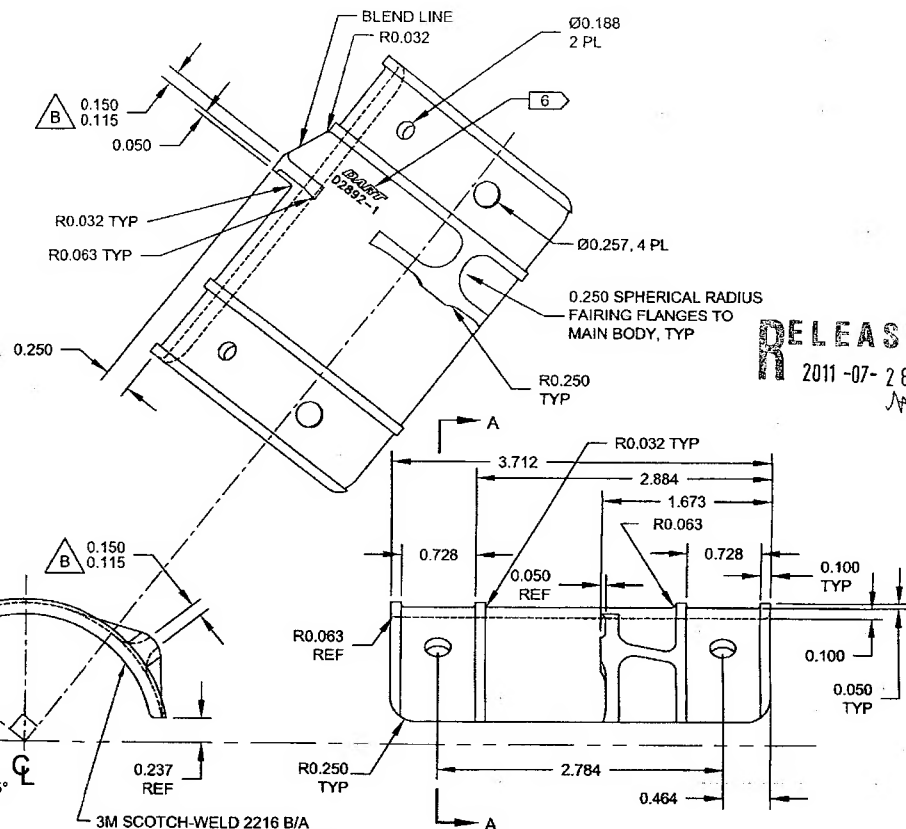
Measured by:	DAS 08	Date:	12/11/02
Audited by:	DAS 14	Date:	12/11/05
Prototype Approval:		Date:	

Rev	Date	Change	Revised by	Approved
A	02.12.12	New Issue	KJ/RF	
B	08.04.21	Reformat	KJ/JLM	
C	12.01.31	Dwg Rev updated	KJ	

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NOTES:

- 1) MATERIAL: 17-4 PH STAINLESS STEEL, H900 OR H925 CONDITION
MIN UTS = 170 KSI (38 HRC)
(REF DART SPEC. D6104)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 (REF. X.XXX = ± 0.010) UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: DART LOGO (PER DART SUPPLIED GRAPHIC) AND PART NUMBER IN THIS AREA WITH 0.125 HIGH LETTERING
0.010-0.020 DEEP, PER DART QSI 044 6.3.
- 7) WEIGHT: 0.41 lb
- 8) FOR THE ENTIRE INNER CONCAVE SURFACE:
ABRADE SURFACE WITH 400-GRIT SANDPAPER. REMOVE RESIDUE WITH MEK (OR EQUIVALENT). APPLY 0.03" TO 0.05" THICK LAYER OF 3M SCOTCH-WELD 2216 B/A ADHESIVE TO MATING SURFACE OF SUPPORT. ALLOW TO CURE FOR 24 HOURS.



D2892-1 SUPPORT

B	RMV FINISH, ADD 3M 2216, ADD H925 MAT'L OPTION, UPDATE TOLERANCE (ZIN D5-1, B5-1, B6-1)	CP	11.07.15
A	NEW ISSUE	CP	00.11.17
REV.	DESCRIPTION	BY	DATE
DESIGN	qp	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	qp		
CHECKED	ASS		
MFG. APPR.	[Signature]		
APPROVED	[Signature]		
DE APPR.	[Signature]	DRAWING NO. D2892 TITLE Ø2.500 SUPPORT SCALE NTS	
DATE	11.07.15	<small>COPYRIGHT © 2000 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL. NO DISSEMINATION OR REPRODUCTION OF THIS DOCUMENT IS TO BE MADE WITHOUT THE WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

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 WORK ORDER

NO 91936 MWS

12-10-22

